

Abstract of the Disclosure

10 A novel blend, film, and patch bag combination of: (a) a bag having inside and outside surfaces comprising a flexible, thermoplastic, biaxially stretched, heat shrinkable film having at least one blend layer having at least three copolymers comprising: 45 to 85 weight percent of a first polymer (having a melting point of 55 to 98°C) comprising a copolymer of ethylene and hexene-1 or octene-1; 5 to 35 weight % of a second polymer (having a melting point of from 115 to 128°C) comprising a copolymer of ethylene and at least one  $\alpha$ -olefin; and 10 to 50 weight percent of a third polymer (having a melting point of from 60 to 110°C) comprising an unmodified or anhydride-modified copolymer of ethylene and a vinyl ester, acrylic acid, methacrylic acid, or an alkyl acrylate; where the first and second polymers above have a combined weight percentage  $\geq 50$  weight % based upon their total weight; and the bag film has a total energy absorption  $\geq 0.70$  Joule and a shrinkage value at 90°C  $\geq 50\%$  in at least one of the machine and transverse directions; and (b) a patch film attached to at least one surface of the bag and covering at least 25% of the bag's surface where this patch film comprises a flexible, thermoplastic film comprising a blend of  $\geq 2$  polymers comprising:

5 to 20 weight % of (i) an ionomer polymer e.g. an ethylene-methacrylate acid copolymer whose acid groups have been neutralized partly or completely to form a salt, preferably a zinc or sodium salt;

5 to 95 weight percent of (ii) a copolymer of ethylene and at least one  $C_6$  to  $C_8$   $\alpha$ -olefin, (melting point of from 55 to 95°C and  $\overline{M}_w/\overline{M}_n$  of 1.5 to 3.5);

0 to 90 weight percent of (iii) a copolymer of ethylene and at least one  $C_4$  to  $C_8$   $\alpha$ -olefin, (melting point of 100 to 125°C); and

0 to 90 weight percent of (iv) a copolymer of propylene and ethylene or butene-1 (melting point of 105 to 145°C);

0 to 90 weight percent of (v) a copolymer of ethylene and hexene-1, octene-1 and/or decene-1, (melting point of 125 to 135°C); and polymers (ii), (iii), (iv), and (v) have a combined weight % of  $\geq 80$  weight % based upon the total weight of polymers (i), (ii), (iii), (iv), and (v); and the patch film has a total energy absorption of  $\geq 1.2$  Joule, and process for making same.